

Work Order ID 69141

Tuesday, May 03, 2011 10:54:04 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop



Start Date: 5/3/2011 Start Qty: 1.00



Ship - May 18th

Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: 115928 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

PC 11-05-17

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

BE
11-05-17

1 *0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69141

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Item ID:	D3914-041	Accept		Setup	Start	
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Start Date:	5/3/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	5/9/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC6- Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control									

AA 11.05.17

130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							

M 11.5.17

1 BL 11.5-17

Powder Coating

*** mask sides of hinge prior to powdercoat***

Start Time: *2:45*

Oven Temperature: *320°*

Finish Time: *3:15*

140	Wing Walk as per dwg QSI005 4.4 Batch <i>M 117315</i>	0.00							
HandFinish	Memo	0.00							

1 φ M 11/05/15

Hand Finishing

✓ 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

✓ 2- Install placard and label as per dwg

Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label

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Setup Start



Revision ID:

Stop



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Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/05/18

160

Identify as per dwg & Stock Location: W10

0.00



Packaging

Memo

0.00

Packaging

D-1030-041 / 869134

11/05/18

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/15/18

11/05/18

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Picklist Print

Tuesday, May 03, 2011 10:54:11 AM

Page 1

Work Order ID: 69141

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)



Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581 Mounting Bracket		Manufactured	No			100	Each	12.0000	2	2			
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Location	Loc Qty	Loc Code
WA005	12	
66806	12	

B68944 → ②

D3914-1 Rib		Manufactured	No			100	Each	0.0000	2	2			
--------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

B69165 → ② PL11.05.17

D3914-7 Rib		Manufactured	No			100	Each	6.0000	2	2			
--------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	1	
66620	1	
WA006	5	
66980	1	
68175	4	

②

D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	6.0000	3	3			
--------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA005	6	
67040	6	

B68572 → ③

W/O:		WORK ORDER CHANGES					
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Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

D4018-5

Manufactured No

100 Each

23.0000

9 9



Rib



PL11.05.17

Location

Loc Qty

Loc Code

WA005

23

B69013 → ⑨

67041

23

D4020-5

Manufactured No

100 Each

1.0000

1 1



Mesh (350 Basket Long, Lid)



PL11.05.17

Location

Loc Qty

Loc Code

WA

1

B69293 → ⑩

66518

1

D4021-3

Manufactured No

100 Each

4.0000

1 1



Data Plate



PL11.05.17

Location

Loc Qty

Loc Code

WA005

4

①

66721

4

D4035-041

Manufactured No

100 Each

5.0000

1 1



Lid Rib Assembly, Fwd (350 Basket)



PL11.05.17

Location

Loc Qty

Loc Code

WA006

5

67337

1

67374

4

①

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, May 03, 2011 10:54:11 AM

Page 3

Work Order ID: 69141



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-043

Manufactured No

100

Each

7.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



Pl 11:05:17

Location

Loc Qty

Loc Code

WA006

7

67336

1

67375

6

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label



1115050

011 11 10:51:18

Tuesday, May 03, 2011 10:54:11 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4018-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69142

11-05-3

RELEASED
10.08.17
ECS 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 REV. B SHEET 1 OF 4 TITLE LONG BASKET LID ASSY (350) SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS TO BE SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	WJ		
DE APPR.	WJ		
DATE	10.08.05		

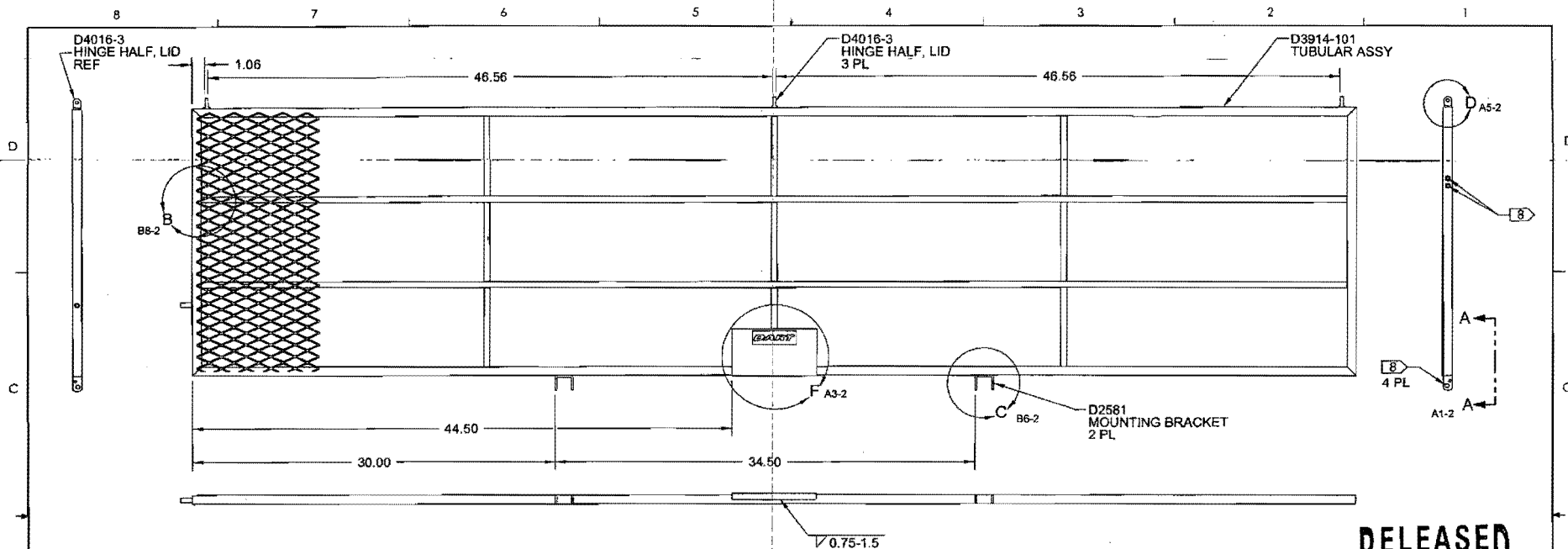
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

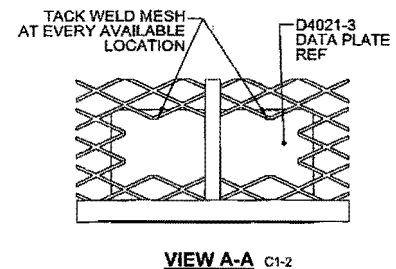
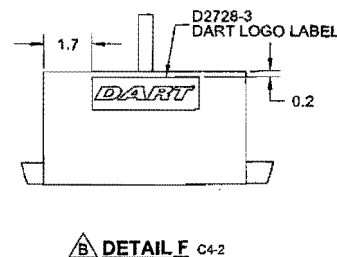
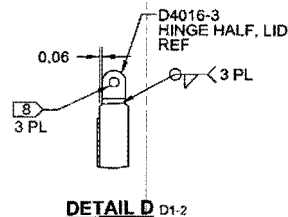
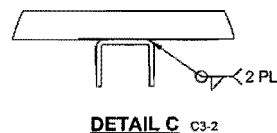
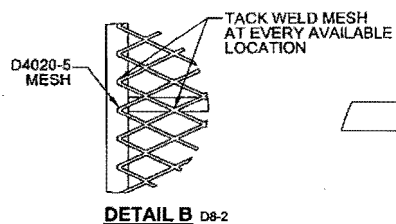
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NOTE: Date & initial all entries



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



RELEASED
10.08.12 CP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O 69142

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

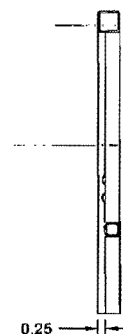
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

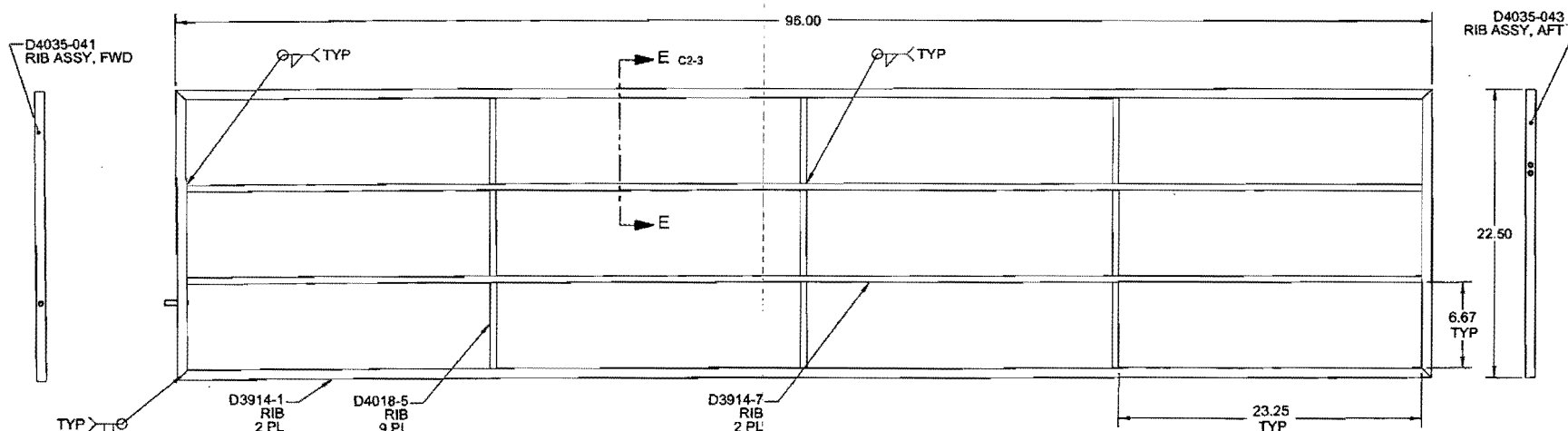
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-12 CP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO. D3914	REV. B
CHECKED	SC	SHEET 3 OF 4	
MFG. APPR.	SC	TITLE LONG BASKET LID ASSY (350)	SCALE NTS
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w/o 09142

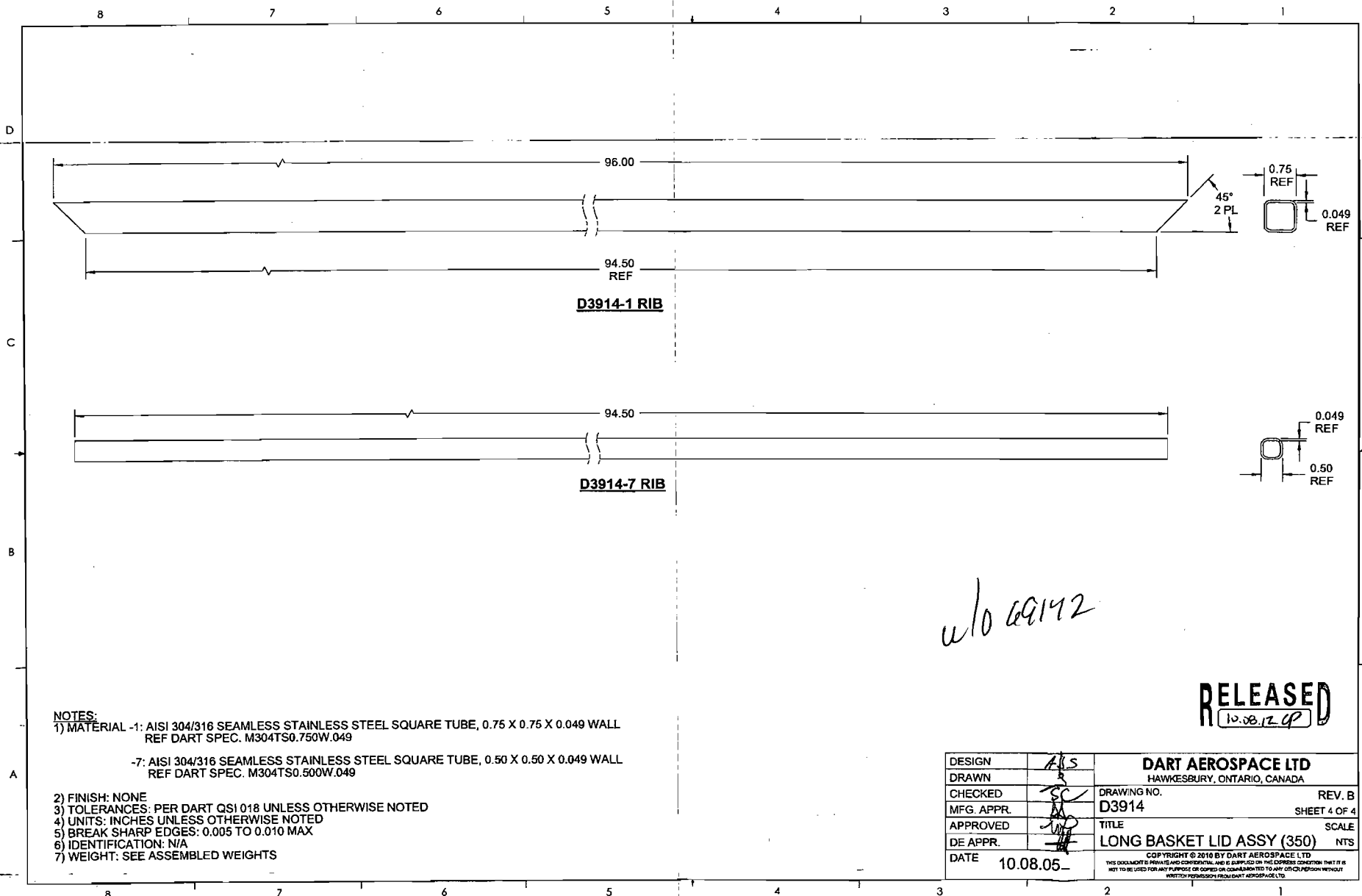
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NOTES:

- 1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

w/ 69142

RELEASED
10.08.12.05

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO. D3914	REV. B
MFG. APPR.	WJP	SHEET 4 OF 4	
APPROVED	WJP	SCALE	
DE APPR.	WJP	LONG BASKET LID ASSY (350) NTS	
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